

Work Order ID 50582

July 16, 2009 8:26:15 AM



Page 1

Item ID: D3825-041
Revision ID: A
Item Name: Rib Assembly (Basket End)

Accept



Setup Start



Stop



Start Date: 07/17/2009 Start Qty: 6.00
Required Date: 07/22/2009 Req'd Qty: 6.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *MF*
QC:

Date: 09-07-16 Tooling:
Date: SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3825	Rev A

100 0.00



Large Fab

Large Fab

Large Fab

Memo

SAD 09-07-22 0.00
1- cut D3825-1 rib as per dwg D3825 12- drill hole (3/16") in D3825-1 using
DT9438 jig and open to finish size as per dwg D3825 13- c/sink hole as per
dwg 14- remove identification markings 15- deburr

SAD 09-07-22 0.00
PD 09-07-22 6

110 QC5- Inspect part completeness to step on W/O 0.00



QC

Quality Control

Memo

0.00

=> Sad 07/22

6

f

120 Large Fab 0.00



Large Fab

Large Fab

Memo

1- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg
D3825: A/R ER316 S.S. Rod Batch: *1108165* 12- grind
bushing weld flush where indicated on dwg D3825 13- deburr if necessary

PD 09-07-22 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50582

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Page 2

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Required Date: 07/22/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

Cpl 09-07-22

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S 02/4/22

*-41
Ⓢ Ⓟ*

150

Identify as per dwg & Stock Location *Basket*

0.00



Packaging

Memo

0.00

Packaging

PD 09.07.23 Ⓢ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Stop



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Start Date: 07/17/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 07/22/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/23 JF

mf 09-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 16, 2009 8:26:14 AM

Work Order ID: 50582

Parent Item: D3825-041RevA

Parent Item Name: Rib Assembly (Basket End)

Comments:

Start Date: 07/17/2009

Required Date: 07/22/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD		Manufactured	No			100	Each	76.0000	6.0000			
Spacer Bushing												

Warehouse
Location

Loc Qty

Loc Code

Premier

Mezz

78

44274

69

44365

9

Main Warehouse

ST

-2

44274

-2

D3759-1RevA

Manufactured

No

100

Each

60.0000

6.0000

Bushing

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

24

48331

24

Main Warehouse

WA

36

50000

36

6 PD 09.07.22

6 PD 09.07.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

July 16, 2009 8:26:14 AM

Page 2

Work Order ID: 50582

Parent Item: D3825-041RevA

Parent Item Name: Rib Assembly (Basket End)

Comments:

Start Date: 07/17/2009

Required Date: 07/22/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	174.1729	13.4211			



304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	174.172879	
110969	3.29	
111148	15.96	
111331	1.96	
111432	0.44	
111885	5.9122	
112051	146.610679	

13.4211 SAD 09-07-23 (24/2)

July 16, 2009 8:26:14 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

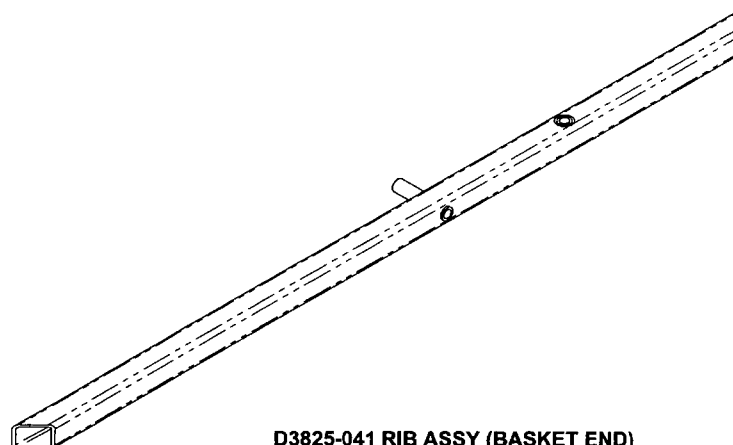
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50582
MP 09-07-16

RELEASED
08/11/16

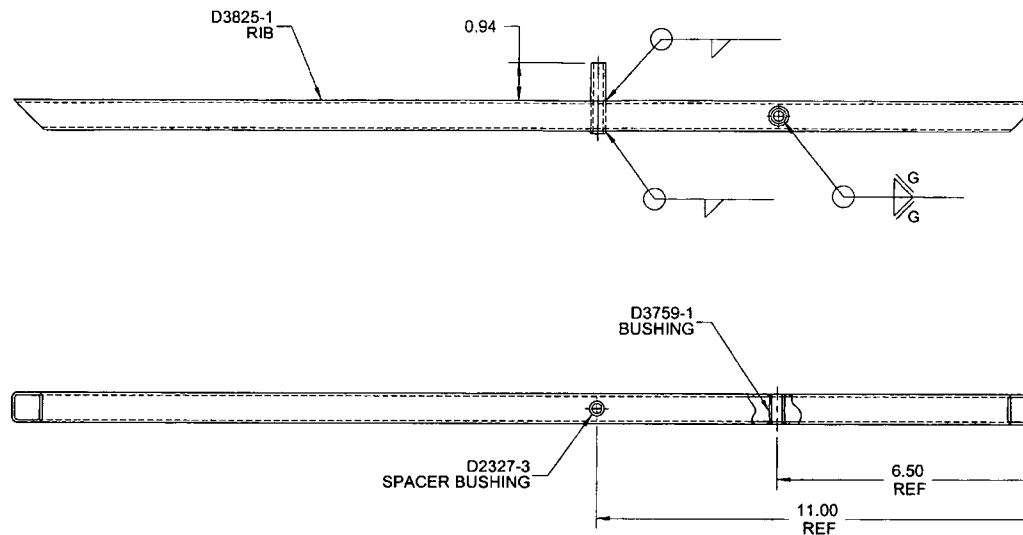
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.22 lbs
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3825** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET END)** SCALE NTS

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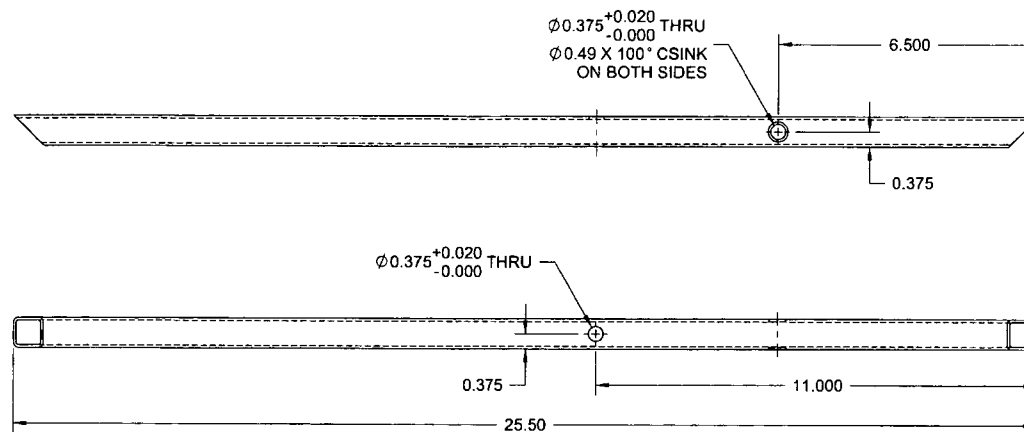
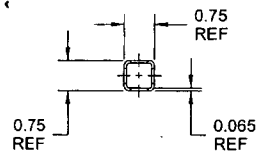
D3825-041 RIB ASSY (BASKET END)

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WORK ORDER
NO. 50582

MF 09-07-16

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08/11/18 JWW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>ASS</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>ASS</u>	D3825	SHEET 2 OF 3
APPROVED	<u>ASS</u>	TITLE	SCALE
DE APPR.	<u>ASS</u>	RIB ASSY (BASKET END)	NTS
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D3825-1 RIB

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WORK ORDER

NO 50582
MR 09-07-16

RELEASED
08/11/13 MB

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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